



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D4635-144**  
**Job Sheet 167086-G**



Part No: D4635-144

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |
| 90    | Start up Operation | 1 Ea  |            | 11/9/17  | 0.00      | 0.00    | Start up container    | 5h        |
| 100   | HandThermo         | 1 pcs |            | 11/9/17  | 0.00      | 1.16    | HandFinish4           |           |
| 110   | Small Fab          | 1 pcs |            | 11/10/17 | 0.00      | 1.57    | Small Fab             |           |
| 120   | QC                 | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | QC5                   |           |
| 130   | Packaging          | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | Packaging3            |           |
| 140   | QC21-SA            | 1 Ea  |            | 11/10/17 | 0.00      | 0.00    | QC21                  |           |

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: \_\_\_\_\_ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # \_\_\_\_\_ Expiry Date \_\_\_\_\_ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: \_\_\_\_\_

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: \_\_\_\_\_

140 - QC21- Final Inspection - Work Order Release

### Job Allocations

| Operation             | Component Part   | Required | Inventory | Allocated | Std Qty |
|-----------------------|------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D4635-4 5021780  | 1        | 2         | 0         | 0       |
|                       | D4669-1          | 1        | 27        | 0         | 0       |
|                       | D4695-4 5024333  | 1        | 2         | 0         | 0       |
|                       | D4732-11 5022779 | 1        | 5         | 0         | 0       |
|                       | D4732-39 5022778 | 1        | 6         | 0         | 0       |
|                       | D4732-41 5021777 | 1        | 6         | 0         | 0       |
|                       | D5022-5 5022776  | 1        | 2         | 0         | 0       |

### Part Specifications

Specifications could not be found.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                      |                          |                                   |                          |            |                          |                     |                          |             |                          |
|--------------------------------------------------------------|----------------------|--------------------------|-----------------------------------|--------------------------|------------|--------------------------|---------------------|--------------------------|-------------|--------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b>   |                          | <b>AGAINST DEPARTMENT/PROCESS</b> |                          |            |                          |                     |                          |             |                          |
|                                                              | Rework               | <input type="checkbox"/> | Skid-tube                         | <input type="checkbox"/> | Cross tube | <input type="checkbox"/> | Water Jet           | <input type="checkbox"/> | Engineering | <input type="checkbox"/> |
|                                                              | Scrap                | <input type="checkbox"/> | Machining                         | <input type="checkbox"/> | Small Fab  | <input type="checkbox"/> | Prod. Eng. Coord.   | <input type="checkbox"/> | Quality     | <input type="checkbox"/> |
|                                                              | Use-as-is            | <input type="checkbox"/> | Thermoforming                     | <input type="checkbox"/> | Finishing  | <input type="checkbox"/> | Rec/Store/Packaging | <input type="checkbox"/> | Other       | <input type="checkbox"/> |
|                                                              | Suspected Unapproved | <input type="checkbox"/> | Large Fab                         | <input type="checkbox"/> | Composite  | <input type="checkbox"/> | Supplier            | <input type="checkbox"/> |             | <input type="checkbox"/> |

Date : \_\_\_\_\_ Step #: \_\_\_\_\_ QTY Effective : \_\_\_\_\_ MRB (QSI042) Approval \_\_\_\_\_

Description Work Order Deviation

**DART**  
AEROSPACE  
**S026624**

**Aft Ceiling Replacement Panel Assembly, RH**

**PART NO:**  
**Revision:**  
**Operation:**  
**Change No:**

**D4635 - 144**

**Start up Operation**

**Mfg Date: 12/22/17**  
**Job No: 167086 - G**

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Completed By \_\_\_\_\_

and / Supervisor  
Approval Verification

A Coordinator  
Approval

ed Wrong  
Dimensions  
der tolerance  
rect

|                    |                          |                       |                          |                    |                          |                                 |                          |                       |                          |
|--------------------|--------------------------|-----------------------|--------------------------|--------------------|--------------------------|---------------------------------|--------------------------|-----------------------|--------------------------|
| <b>Root Cause</b>  |                          |                       |                          |                    |                          |                                 |                          |                       |                          |
| Environment        | <input type="checkbox"/> | No Re-verification    | <input type="checkbox"/> | Pressure/Fo        | <input type="checkbox"/> |                                 | <input type="checkbox"/> | Out of Sequence       | <input type="checkbox"/> |
| Design             | <input type="checkbox"/> | Operator              | <input type="checkbox"/> | Bending            | <input type="checkbox"/> |                                 | <input type="checkbox"/> | Off-set               | <input type="checkbox"/> |
| Doc/Data           | <input type="checkbox"/> | Offset/Setup          | <input type="checkbox"/> | Centre Not C       | <input type="checkbox"/> |                                 | <input type="checkbox"/> | Mislabeled            | <input type="checkbox"/> |
| Equip/Tooling      | <input type="checkbox"/> | Supplier              | <input type="checkbox"/> | Cracks             | <input type="checkbox"/> |                                 | <input type="checkbox"/> | Fit/Function          | <input type="checkbox"/> |
| Handling/Pre       | <input type="checkbox"/> | Training              | <input type="checkbox"/> | Crimp/Kink/Ri      | <input type="checkbox"/> |                                 | <input type="checkbox"/> | Misaligned/off center | <input type="checkbox"/> |
| Material           | <input type="checkbox"/> | Use for Testing       | <input type="checkbox"/> | Cuffs              | <input type="checkbox"/> |                                 | <input type="checkbox"/> | Part Lost/Missing     | <input type="checkbox"/> |
| Internal Transport | <input type="checkbox"/> | Poor Information      | <input type="checkbox"/> | Crushing           | <input type="checkbox"/> | Countersink                     | <input type="checkbox"/> | Drawing               | <input type="checkbox"/> |
| Tribal Knowledge   | <input type="checkbox"/> | Rushing               | <input type="checkbox"/> | Heat Treat         | <input type="checkbox"/> | Cut Too Short                   | <input type="checkbox"/> | Finish                | <input type="checkbox"/> |
| LOA                | <input type="checkbox"/> | Product Improvement   | <input type="checkbox"/> | Wave/Twist in Tube | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> | Misread               | <input type="checkbox"/> |
| Substation         | <input type="checkbox"/> | Process Improvement   | <input type="checkbox"/> | Marks/Chatter      | <input type="checkbox"/> | Drill Holes                     | <input type="checkbox"/> | Turning Sequence      | <input type="checkbox"/> |
| Past Expiry Date   | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> |                    |                          |                                 |                          |                       |                          |
| Misidentified      | <input type="checkbox"/> | Past Due              | <input type="checkbox"/> |                    |                          |                                 |                          |                       |                          |
|                    |                          |                       |                          | OTHER : _____      |                          |                                 |                          |                       |                          |